



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**RB23003267-3**  
**Job Sheet 194011**



**Part No:** RB23003267-3

**Job Qty:** 2 pcs

**Part Name:** #56 Drill Bit & Block Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/25/19

**Job Tracking No:**

**Due Date:** 5/31/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG RB23003267 Rev.4 IPP Rev. A 19.02.13 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                                                     |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------------------------------------------------------|
|       |                     |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                                              |
| 100   | Small Fab - 1       | 2 pcs | 5/31/19    |          | 0.00      | 0.25    | Small Fab - 1         |           | MCC                                                          |
|       |                     |       |            |          |           |         | Small Fab - 2         |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 3         |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 4         |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 5         |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 6         |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 7         |           |                                                              |
| 110   | QC 5                | 2 pcs | 5/31/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 12             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 17             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 18             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 19             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 22             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 24             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 3              |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 43             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 49             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 51             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 58             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 68             |           |                                                              |
|       |                     |       |            |          |           |         | QC 5 - 9              |           |                                                              |
| 120   | Small Fab - 2 - B4B | 2 pcs | 5/31/19    |          | 0.00      | 0.20    | Small Fab - 1 - B4B   |           | DAS<br>40<br>9-89<br>MAY 30 2019<br>NIA<br>DAS<br>21<br>9-89 |
|       |                     |       |            |          |           |         | Small Fab - 2 - B4B   |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 3 - B4B   |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 4 - B4B   |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 5 - B4B   |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 6 - B4B   |           |                                                              |
|       |                     |       |            |          |           |         | Small Fab - 7 - B4B   |           |                                                              |



**Container No:** S185252



**Part:** RB23003267-3

**Job No:** 194011

**Serial No/Batch:** S185252

**Revision:** 4

**Inspector:**

**Exp Date:**

**Instructions:**

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www.dartaerospace.com

Date: 05/29/19

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|                                 |       |         |           |                        |  |
|---------------------------------|-------|---------|-----------|------------------------|--|
| 125 QC 5                        | 2 pcs | 5/31/19 | 0.00 0.00 | QC 5 - 10              |  |
|                                 |       |         |           | QC 5 - 12              |  |
|                                 |       |         |           | QC 5 - 17              |  |
|                                 |       |         |           | QC 5 - 18              |  |
|                                 |       |         |           | QC 5 - 19              |  |
|                                 |       |         |           | QC 5 - 22              |  |
|                                 |       |         |           | QC 5 - 24              |  |
|                                 |       |         |           | QC 5 - 3               |  |
|                                 |       |         |           | QC 5 - 43              |  |
|                                 |       |         |           | QC 5 - 49              |  |
|                                 |       |         |           | QC 5 - 51              |  |
|                                 |       |         |           | QC 5 - 58              |  |
|                                 |       |         |           | QC 5 - 68              |  |
|                                 |       |         |           | QC 5 - 9               |  |
|                                 |       |         |           | QC 5 - 50              |  |
|                                 |       |         |           | QC 5 - 30              |  |
|                                 |       |         |           | QC 5 - 40              |  |
|                                 |       |         |           |                        |  |
|                                 |       |         |           |                        |  |
|                                 |       |         |           |                        |  |
|                                 |       |         |           |                        |  |
| 130 Packaging 3-1 - Stock - B4B | 2 pcs | 5/31/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 2 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 3 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 4 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 5 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 6 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 7 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 8 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 9 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 10 - B4B |  |
|                                 |       |         |           | Packaging 3 - 11 - B4B |  |
|                                 |       |         |           | Packaging 3 - 12 - B4B |  |
|                                 |       |         |           | Packaging 3 - 13 - B4B |  |
|                                 |       |         |           | Packaging 3 - 14 - B4B |  |
|                                 |       |         |           | Packaging 3 - 15 - B4B |  |
|                                 |       |         |           | Packaging 3 - 16 - B4B |  |
|                                 |       |         |           | Packaging 3 - 17 - B4B |  |
|                                 |       |         |           | Packaging 3 - 18 - B4B |  |
|                                 |       |         |           | Packaging 3 - 19 - B4B |  |
|                                 |       |         |           | Packaging 3 - 20 - B4B |  |
|                                 |       |         |           | Packaging 3 - 21 - B4B |  |
|                                 |       |         |           | Packaging 3 - 22 - B4B |  |
|                                 |       |         |           | Packaging 3 - 23 - B4B |  |
|                                 |       |         |           | Packaging 3 - 24 - B4B |  |
|                                 |       |         |           | Packaging 3 - 25 - B4B |  |
|                                 |       |         |           | Packaging 3 - 26 - B4B |  |
|                                 |       |         |           | Packaging 3 - 27 - B4B |  |
|                                 |       |         |           | Packaging 3 - 28 - B4B |  |
|                                 |       |         |           | Packaging 3 - 29 - B4B |  |
|                                 |       |         |           | Packaging 3 - 30 - B4B |  |
|                                 |       |         |           | Packaging 3 - 31 - B4B |  |
|                                 |       |         |           | Packaging 3 - 32 - B4B |  |
|                                 |       |         |           | Packaging 3 - 33 - B4B |  |
|                                 |       |         |           | Packaging 3 - 34 - B4B |  |
|                                 |       |         |           | Packaging 3 - 35 - B4B |  |
|                                 |       |         |           | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - SA                  | 2 pcs | 5/31/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                                 |       |         |           | QC 21 - SA - 70        |  |
|                                 |       |         |           | QC 21 - SA - 53        |  |

NIA

DAS  
21  
9-89DAS  
20  
9-89DAS  
21  
9-89  
MAY 31 2019

Part Op 100 - Assemble as per drawing using LOC TITE multipurpose epoxy.  
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)  
 120 - Laser engrave as per drawing

130 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
140 - (QC21- Final Inspection - Work Order Release)

**Job BOM**

| Part / Item   | Component Name | Quantity     | Operation         | Container |
|---------------|----------------|--------------|-------------------|-----------|
| RB23003267-3A | #56 Drill Bit  | 2 pcs (1 ea) | 100-Small Fab - 1 | 516 950 2 |
| RB23003267-3B | Block          | 2 pcs (1 ea) | 100-Small Fab - 1 | 516 090 2 |

**Job Allocations**

| Operation         | Component Part | Required | Inventory | Allocated |
|-------------------|----------------|----------|-----------|-----------|
| 100-Small Fab - 1 | RB23003267-3A  | 2        | 2         | 0         |
|                   | RB23003267-3B  | 2        | 6         | 0         |

**Part Specifications**

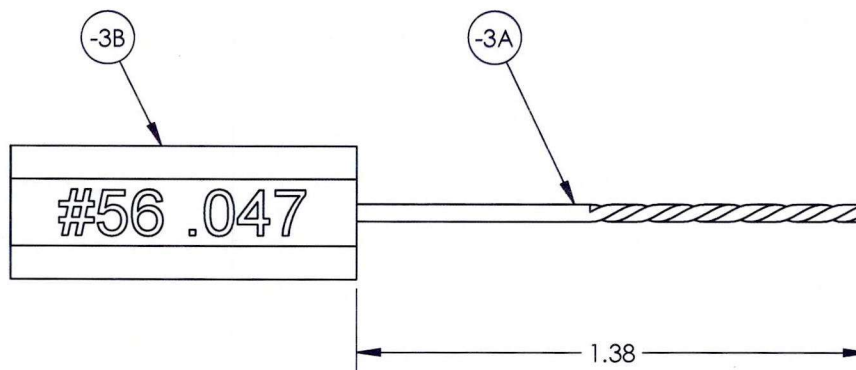
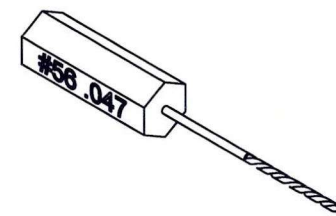
Specifications could not be found.

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| REVISIONS |     |             |      |         |          |
|-----------|-----|-------------|------|---------|----------|
| REV       | ECR | DESCRIPTION | DATE | INITIAL | APPROVED |



SNCP COPY  
RETURN TO  
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IN FACT TO AMENDMENT

NOT OUT NOTICE  
WORK ORDER  
194011 MLW  
1904-21

NOTE:  
ASSEMBLE WITH EPOXY.



TITLE POWER TURBINE CLEANING KIT

DWG NO. RB23003267-3 REV 4

|            |          |                                                        |                 |
|------------|----------|--------------------------------------------------------|-----------------|
| MAT'L      |          | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |                 |
| FEAT       |          | .XXX ± .005                                            | FRACTIONS ± 1/8 |
| TREAT      |          | .XX ± .01                                              | ANGLES ± 5°     |
| FINISH     |          | .X ± .1                                                | SURFACES = 125/ |
| SPEC       |          | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R        |                 |
| DRAWN BY:  | CLOUGH   | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING           |                 |
| CHECKED:   | CLOUGH   | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009       |                 |
| OPPS APPR: | ANDERSON | USED ON MODEL                                          |                 |
| QA APPR:   | LINDSAY  | SEE NOTE 1, SHEET 1                                    |                 |
| APPROVED:  | GILBERT  |                                                        |                 |
| SCALE      | 2:1      | DATE                                                   | 1/17/2001       |
|            |          | SHEET 3 OF 18                                          |                 |

-3

#56 DRILL BIT ASSEMBLY

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------|------------------------|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |              |                        |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042) |                        |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              | Completed By           |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              | Lead hand / Supervisor |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              | QC / QA Coordinator    |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |              |                        |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |